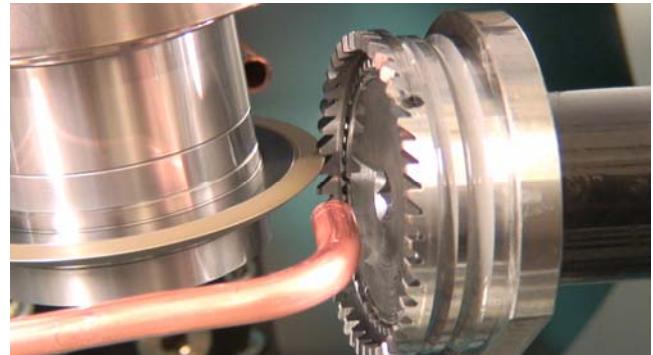


## Special gear

A40-900

This special gear is part of an airplane engine.  
Dressing of the grinding wheel with CNC-dressing  
unit, grinding of two very precise angle following a  
profil dxf.



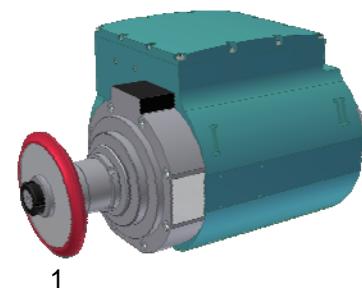
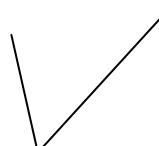
### 1. Cycletime for Production

Specifications			
Diameter 130 mm, Z5			
Operations	Probe	Dress	Cam
Feed [mm/Min]	2000	150	150
Power [kW]		1	1
Cutting feed [m/s]		32	24
Used wheels			1
Grinding time [s]	20	120	360
Total cycle time	8 Min 20		

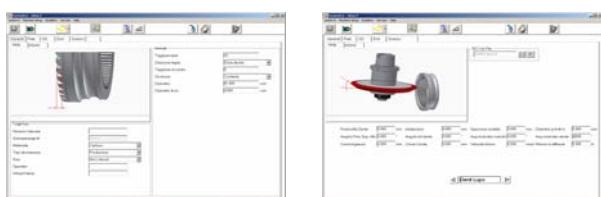
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1 Ø36 DXF Conventional



### 3. Machine and Software Requirements



Machines: 5 axes CNC grinders : NORMA CFG  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 5, DXQ  
Engineer: Di, 01.04.2009



